

Aero Design Ltd.**Work Order Control Sheet**

Work Order#: 2015-38 Date Opened: 17 Apr 2015 Title: Fabrication
Aircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Standard Quantity: 5

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69811	3	Body	JR
69821	1	Regular Hoop	JR
69823	1	Mount Hoop	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

5
N/A
N/A
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: J Rekve for M Rekve

Sign: 

SCA: AD01

Date: 23-May-15

ICC / Dual Inspection preformed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 23-May-15

Work Order closed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 23-May-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

CARGO BASKET HOOP FABRICATION - 69822

General

These instructions apply to cargo basket aft attachment hoop 69822-01. Refer to the following drawings, at the current revision, for dimensions and details:

69822, Revision 1 – Aft Attachment Hoop

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

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Complete
(initial or SCA #)

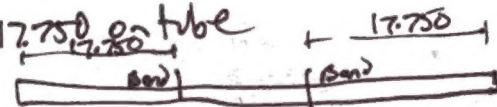
Date Open: 17 APR 2015

AD06

1. Aft Attachment Hoop Fabrication – 69822-01

- a. Cut $\frac{1}{2}$ " x 0.035 material to ~~27"~~ ^{48"}, square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ~~19"~~ ^{Bender mark to 17.750}
 - ii. Lower bend stop: ~~12mm~~ ^{LOWER 104°}
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Using the welding table bending fixture, mark tube at (??) and (??)
- k. Bend lower joggle to ?? degrees in both directions at marks
- l. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: 19"
 - ii. Lower bend stop: 12mm
- m. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- n. Slide shim all the way forward on bender to secure tube in die
- o. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- p. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- q. Using the welding table bending fixture, mark tube at (??) and (??)
- r. Bend lower joggle to ?? degrees in both directions at marks

FOR STANDARD
MOUNT HOOP



- s. Check for:
 - i. hoop height: 15.5" (Outside to outside)
 - ii. hoop width just above bends: 22" (outside to outside)
 - iii. joggle height 1.75"
 - iv. adjust upper stop for height if required
 - v. adjust stock length for width if required
 - vi. twist – due to pulling bending arm up or down through bend
- t. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.

2. Aft Attachment Hoop Slots – 69822-01

AD06

- a. Setup manual milling machine with standard steel vise jaw, with a backup bar to prevent the hoop from deflecting while cutting. Set XY 0 on far, right edge of jaw (end of hoop). Shift X along hoop 0.75" and set X 0.
- b. Using 5/8" (0.625) end mill, mill into side of tube in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before milling.
- c. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- d. Tag in process hoop(s) and place into stock.

3. Aft Attachment Hoop – Welding – 69822-01

- a. Attach two 69823-02 lugs to 11" spacing jig using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 2. above. Centre bolts on hoop.
- b. TIG weld lugs into hoop. Weld all around both lugs.
- c. Record lug and welding rod PO/WO on attached material list.
- d. Tag in process hoop(s) and place into stock.

AD-05
x5

4. Aft Attachment Hoop – Finish – 69822-01

AD06

- a. Run 3/8-24 tap through welded lugs.
- b. Inspect hoop for conformity to drawing.
- c. Tag complete and inspected hoop(s) and place into stock.

CARGO BASKET HOOP FABRICATION - 69821

General

These instructions apply to cargo basket forward attachment hoop 69821-01. Refer to the following drawings, at the current revision, for dimensions and details:

49210, Revision 1 – Basket Component - Hoop

69821, Revision 1 – Forward Attachment Hoop

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1. Forward Attachment Hoop – Preparation – 69821-01

AD-05X1

- Start with 49210-02 hoop as stock.
- Setup manual milling machine with standard steel vise jaw, with a backup bar to prevent the hoop from deflecting while cutting. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0.
- Using 5/8" (0.625) end mill, mill into side of tube in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

2. Forward Attachment Hoop – Welding – 69821-01

AD-05X1
AD-05X4

- Attach two 69823-02 lugs to 11" spacing jig using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. above. Centre bolts on hoop.
- TIG weld lugs into hoop using ER70S-2 rod. Weld all around both lugs.
- Record lug and welding rod PO/WO on attached material list.
- Tag in process hoop(s) and place into stock.

3. Forward Attachment Hoop – Finish – 69821-01

AD-05X1

- Run 3/8-24 tap through welded lugs.
- Inspect hoop for conformity to drawing.
- Tag complete and inspected hoop(s) and place into stock.

No 2015-38

B206L/407 STD. BASKET
X5 w/ CUTOUT

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

- 69811, Revision 3 – Standard Low Mounted Basket
- 94511, Revision 0 – Extra-Wide Low Mounted Basket
- 94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
- 76611, Revision 0 – High Mounted Ski Basket
- Options → 70404, Revision 2 – Front end cutout – 698
- 70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

- 77611, Revision 1 – Short Basket
- 76411, Revision 3 – Medium Basket (left or right)
- 78411, Revision 2 – Long Basket
- 94011, Revision 0 – Extra Large (ski) Basket
- Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

- 90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

- 80211, Revision 0 – Short Basket
- 80311, Revision 0 – Medium Basket
- 81111, Revision 0 – Long Basket
- Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

- 95911, Revision 0 – Standard Basket

Bell Medium – left or right

- 75111, Revision 0 – Standard Basket
- 95511, Revision 0 – Extra Large (ski) Basket
- Options 70407, Revision 1 – Front end cutout – 751
- 704, Revision – Front end cutout – 955

MD600

- 82811, Revision 0 – Standard Basket

Options – Applicable to all models

- 70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

XS

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1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

✓ AD06

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05x4
AD-05x1

3. Inspection

- a. Rim for complete welds

AD08

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AD06

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection

- a. Frame assembly for complete welds.

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require $\frac{1}{2}$ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh $\frac{1}{8}$ "- $\frac{3}{16}$ " down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh $\frac{1}{4}$ " down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)
AD-05 x 4

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

AD-05 x 1
AD-05 x 4

9. Weld basket components
 - a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
 - b. TIG weld caps to close top of 1" hoops as applicable.
 - c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
 - d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

ADP

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

DR

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

AK

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

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Material Tracking Sheet
Bell 206L / 407
Standard Basket Fabrication

1 of 2

Date Opened: 17 ~~APR~~ APR 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			69811-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 1		49210-02	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
	. 2	84262	49210-02	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
	. 1		69821-01	Forward Attachment Hoop		
	. 1		69822-01	Aft Attachment hoop		
	. 4		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
	. 2		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 4.g.		70404	70404-01	Option: Front End Cutout		
(optional)			70404-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
			70404-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 75")	3/4-16F Expanded Mild Steel sheet	12130
	. 2		--	Mesh (End - 22" x 15.5")	3/4-16F Expanded Mild Steel sheet	12130

Work Order: 2015-38Material Tracking Sheet
Bell 206L / 407
Standard Basket Fabrication

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Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
Step 8				Weld Mesh		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	14028
Step 9				Weld Basket Components		
	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	295-07
	A/R		--	Welding Rod	ER308L TIG Rod	14023
Step 10				Clean Up	None	
Step 11				Inspection - Final Assembly	None	
Step 12				Powder Coating		

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Material Tracking Sheet

1 of 2

Bell 206L / 407

Date Opened: 17 APR 2015

Standard Basket Hoops

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	15		49210-02	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
				3 HOOPS FROM 2014-36 TO MAKE 18 TOTAL		
Step 1	10		49210-02	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 2				LUGS IN ME. Welding		
	.2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	
	A/R		--	Welding Rod	ER70S-2	14033
Step 3				Inspection	None	
	16		69821-01	Hoop - attachment (forward)		
Step 1				Fabrication		
	.1		49210-02	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 2				LUGS IN 5 ONLY Welding		
	.2		69823-02	Lug	1018 Steel, 5/8" Rod	2014-70
	A/R		--	Welding Rod	ER70S-2	14033
Step 3				Inspection and Finishing	None	

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Material Tracking Sheet

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Bell 206L / 407

Date Opened: _____

Standard Basket Hoops

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	10		69822-01	Hoop - attachment (aft)		
Step 1				Fabrication		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 2				LUGS IN 5 ONLY Welding		
	. 2		69823-02	Lug	1018 Steel, 5/8" Rod	2014-70
	. A/R		--	Welding Rod	ER70S-2	14033
Step 3				Inspection and Finishing	None	



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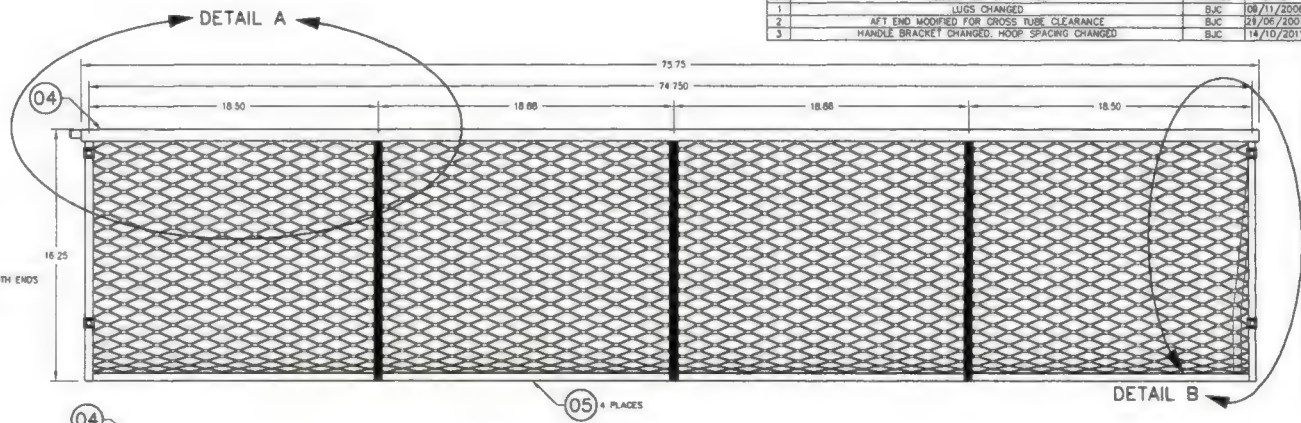
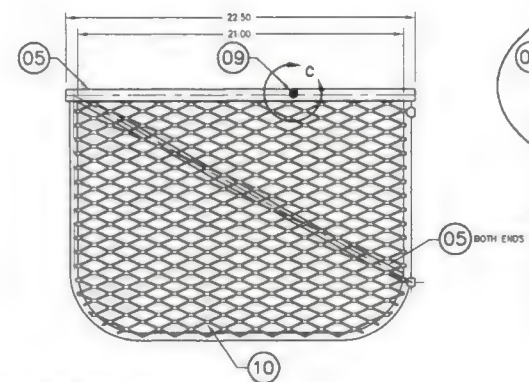
Approved Manufacturing Facility 73-04

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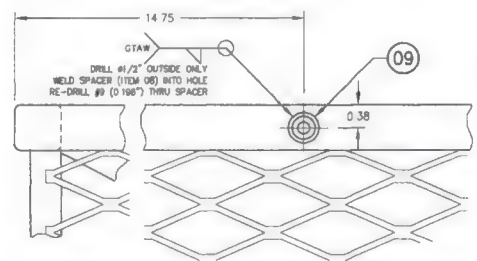
Rev. Original 27 May 2013

2015-38

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LOGS CHANGED	BJC	08/11/2006
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	21/06/2009
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BJC	14/10/2011

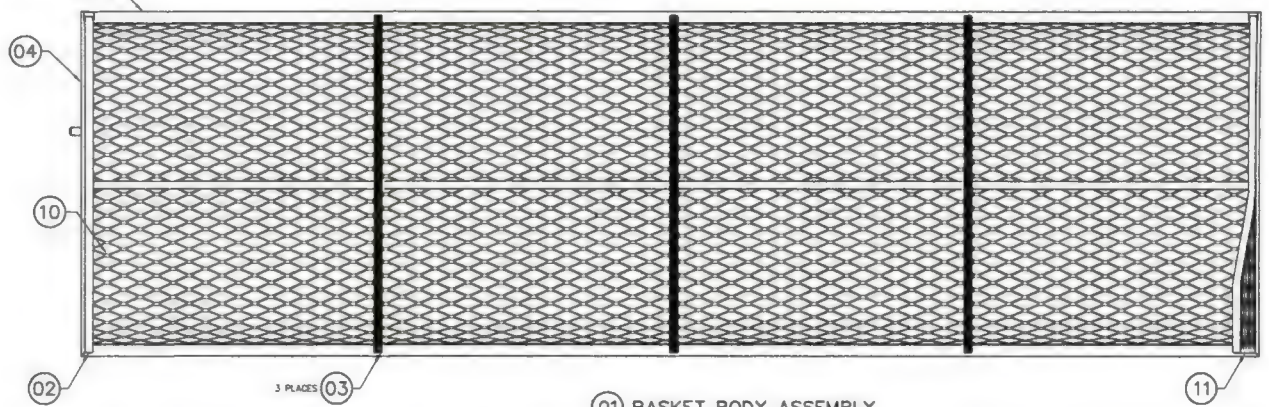


- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C
 3. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
 4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
 5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY

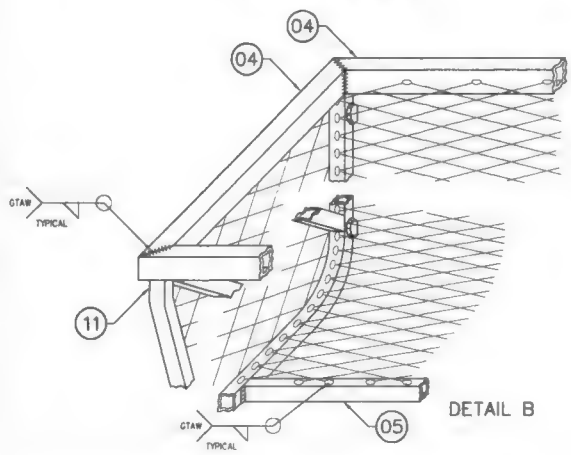


DETAIL C

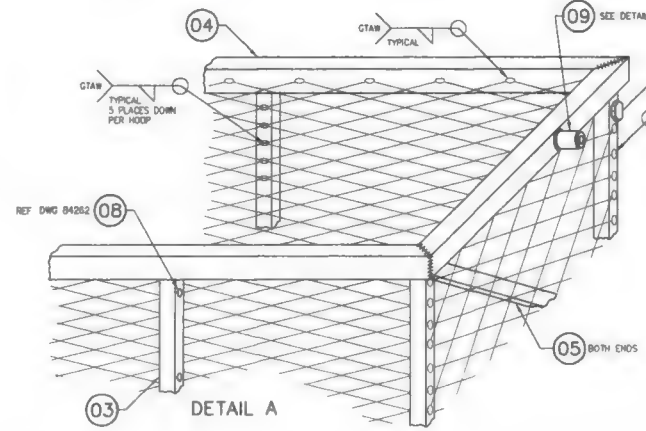
SCALE 1:1
VIEW LOOKING AT FRONT RIM OF BASKET



01 BASKET BODY ASSEMBLY



DETAIL B



DETAIL A

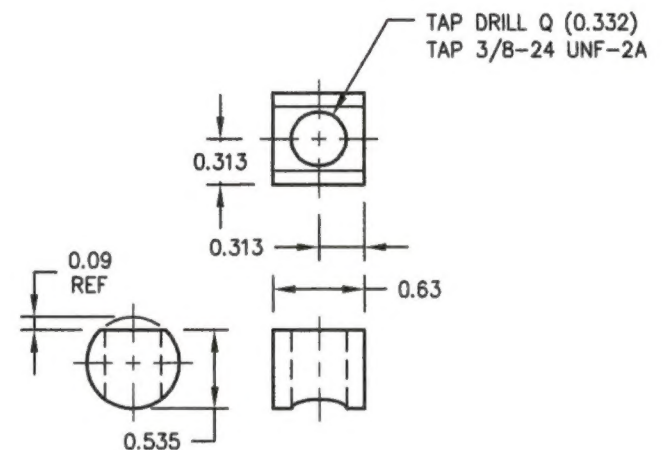
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	69822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-18F	10	MESH			
1	49215-01	09	SPACER			
1	84262-01	08	HANDLE BRACKET ASSEMBLY			
1	---	07	---			
---	---	06	---			
A/R	---	05	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.5 X 0.035 SQR. TUBE
A/R	---	04	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.75 X 0.035 SQR. TUBE
5	49210-02	03	HOOP			
1	69821-01	02	FORWARD END HOOP			
1	69811-01	01	BASKET BODY ASSEMBLY			

APPROVALS		DATE
DRAWN: JEFF CLARKE		11 APR 2006
CHECKED: E. BURGON		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES XXXX ±0.010 ±1/2" XXX ±0.03 X ±0.1		
SCALE 1:4 SHEET 1 OF 1		
DWG NO. 69811 REV 3		

AERO DESIGN LTD.
 CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M
 2015 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6S7
 Tel: (403) 555-8887 Fax: (403) 555-8853 aerodesign@shaw.ca

BELL 206L 407
 QUICK RELEASE CARGO BASKET
 BASKET BODY ASSEMBLY

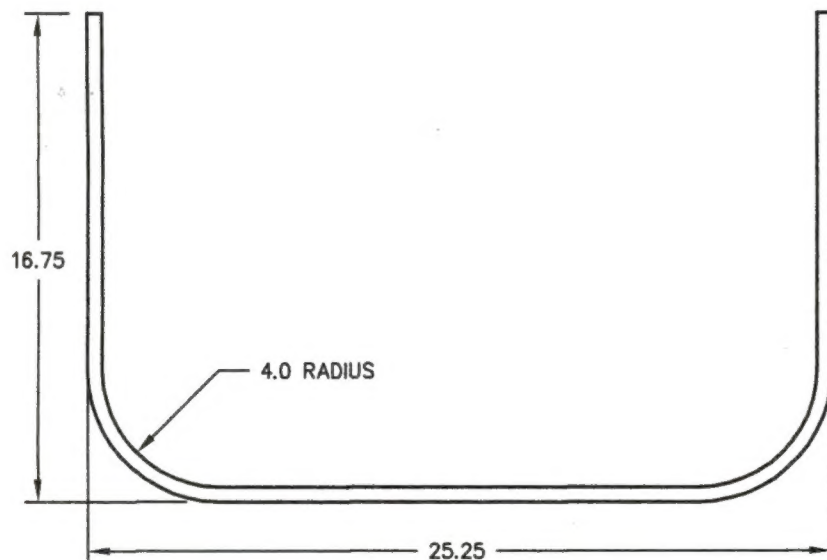
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE LUG (ITEM 1)	BJC	27/02/2007



02 LUG

69823-02	02	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 DIA ROD
	01				
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS				

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	CHECKED: E. BURGOIN		BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET COMPONENTS - LUGS			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:					
	DECIMALS	ANGLES				
	X.XXX	±0.010				
	X.XX	±0.03				
	X.X	±0.1				
NOTICE			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	LGL	69823	1



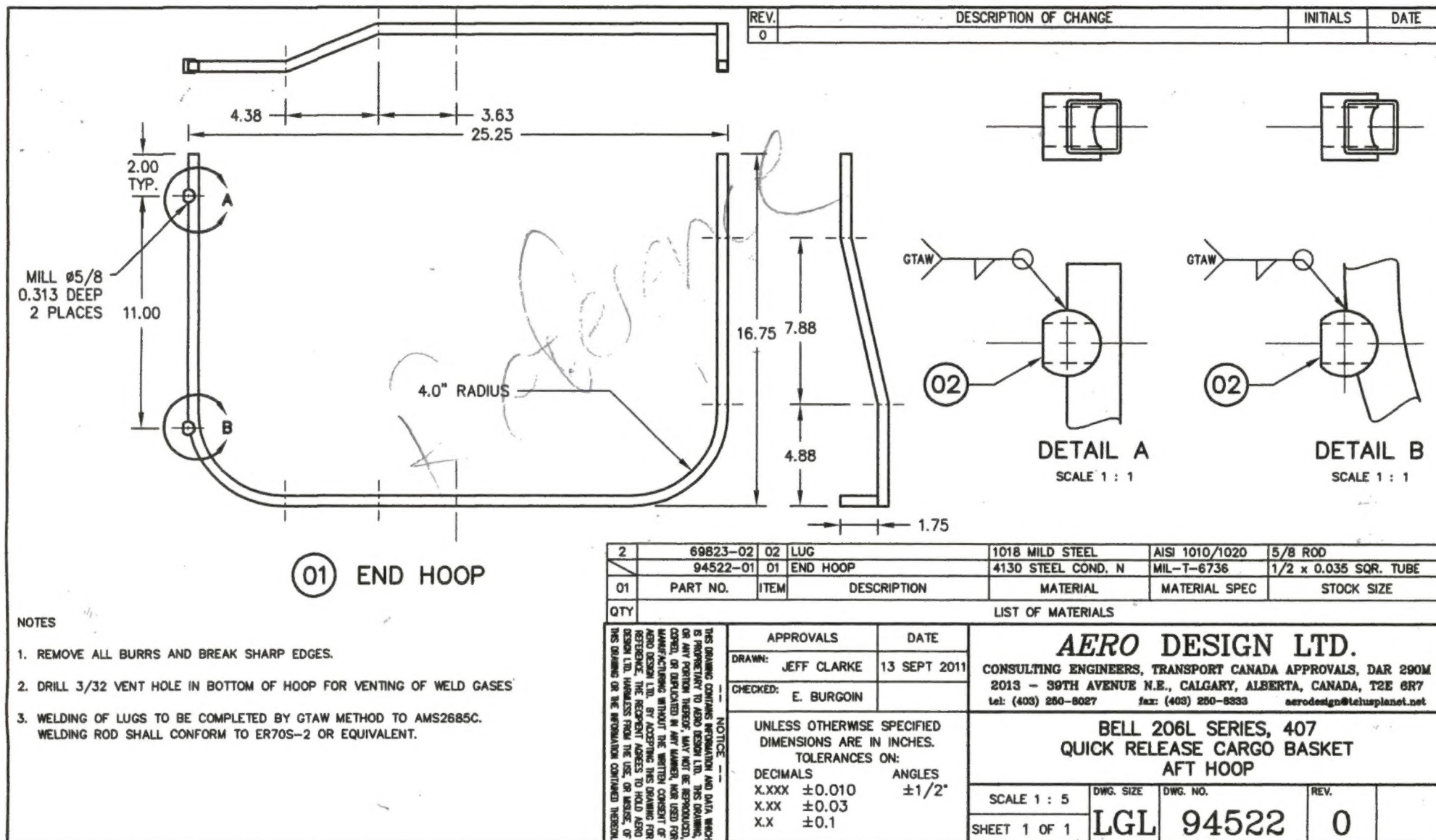
01 HOOP

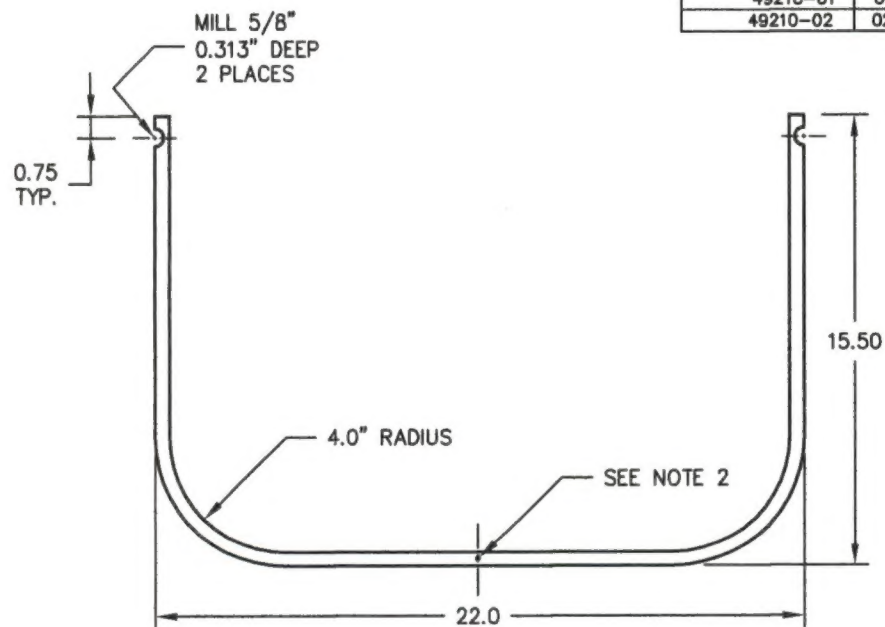
NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

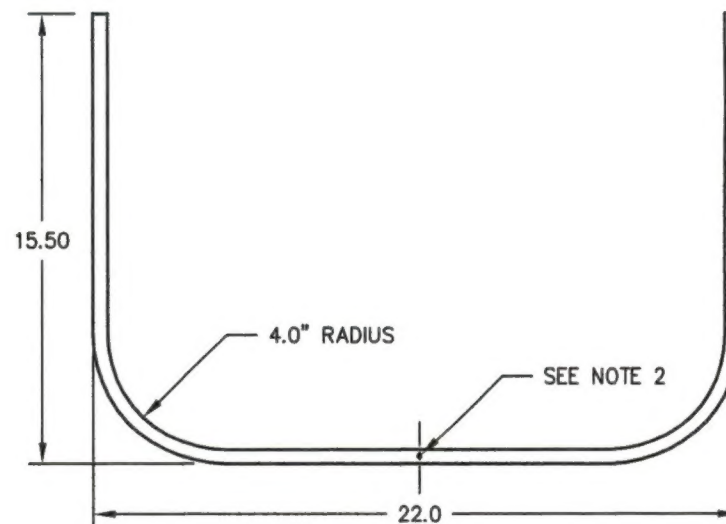
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

94520-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
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			<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.</p> <p>TOLERANCES ON:</p> <p>DECIMALS ANGLES</p> <p>X.XXX ±0.010 ±1/2°</p> <p>X.XX ±0.03</p> <p>X.X ±0.1</p>		<p>AERO DESIGN LTD.</p> <p>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M</p> <p>2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7</p> <p>tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca</p>	
			<p>BELL 206L SERIES, 407</p> <p>QUICK RELEASE CARGO BASKET</p> <p>HOOP</p>		<p>SCALE 1 : 5</p>	
			<p>SHEET 1 OF 1</p>		<p>DWG. SIZE</p> <p>LGL</p>	<p>DWG. NO.</p> <p>94520</p>





① END HOOP



② HOOP

LIST OF MATERIALS					
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
49210-01	01	END HOOP	4130 SQUARE TUBING	MIL-T-6736	#1/2" x 0.035 WALL
49210-02	02	HOOP	4130 SQUARE TUBING	MIL-T-6736	#1/2" x 0.035 WALL

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL #30 (0.129) VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

2	TITLE BLOCK UPDATED; VENT HOLE CHANGED	BJC	22/05/2014
1	HOOP HEIGHT CHANGED	BJC	APR 28/04
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE

NOTICE

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APPROVALS	DATE
DRAWN: STEVEN FAHEY	MAY 10/02
CHECKED: E. BURGON	MAY 10/02



AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.2376 www.aerodesign.ca

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

HELICOPTER CARGO BASKET
BASKET COMPONENTS - HOOPS

SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	LGL	49210	2